

ABSTRACT

10007797-140701
A method for brazing aluminum alloy-assembled
articles with a filler alloy having a liquidus temperature
5 of 540°C or lower and a difference of temperature between
the liquidus temperature and the solidus temperature being
100°C or lower, wherein the highest temperature reached in
the assembled article at the time of heating for brazing
being set 40°C or more higher than the liquidus
10 temperature but 585°C or lower. An aluminum alloy-filler
alloy usable at low temperature for brazing, which
comprises Si in an amount of 4.0 wt% to 8.0 wt%, Zn in an
amount of 7.0 wt% to 20.0 wt% and Cu in an amount of 10.0
wt % to 35.0 wt%, with the balance being made of aluminum.